Page 1

-August-03-12 3:25:20 PM Item ID: D350-567-115 Accept *N900040100* Setup Start **Revision ID:** Item Name: Interior Floor Window Start Qty: 1.00 **Start Date:** 03/08/2012 **Cust Item ID:** Required Date: 17/08/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: MLJ Date: 12/08/03 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Reject Reject Set Up/ Tool# Plan Accept Insp. Work Center ID Description Qty **Run Hours** Code Qty Number Stamp Draw Nbr **Revision Nbr** Rev D IIN-D350-567 0.00 *100* DC 0.00 Document Control Photocopy bluefile and create labels per PPP D350-567-115 CHG004 110 Pick Kit 0.00 12/11/8 /00 *110* Packaging 0.00 Memo Packaging

120

QC4-100% Inspect kits for completeness

0.00

りついか

120

Memo

0.00

Quality Control

NCR:	Yes	/	No
	103	,	110

												DQA:	Date:	- · ·
NCR:	es_	/ No					WORK ORDER NON-C	10:	VFOR	MANCE / UPI	DATE	QA Closed:	Date:	•
Work Orde	er:						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	•
Part f	۱o.					Rework Scrap Use-as-is Work Order Update			Thern	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Desc		tion of work order update		nitial		tion	Sign &		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	nief Eng Description			Date	Verification	QC Inspector
oc/Data quip/Tooling perator Material etup Other rocess upplier raining	-						e de la companya de l							
								VUL	T CATE	GORY				
Landi	anding Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
		Wave/Tw	-				Folio		1	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

QC

Quality Control

-August-03-12 3:25:20 PM Item ID: D350-567-115 Accept *N900040100* Setup Start **Revision ID:** Item Name: Interior Floor Window 03/08/2012 Start Qty: 1.00 **Start Date: Cust Item ID:** Required Date: 17/08/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Start Process Plan: Date: Approvals: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID Description** Qty **Run Hours** Code Qty Number Stamp 130 0.00 Packaging *130* Packaging 0.00 Memo Identify and pack for shipping as per PPP D350-567-115 Packaging Location: PPP Rev: 140 QC21- Final Inspection - Work Order Release 0.00 M1512-11-12

0.00

Memo

												DQA:	Date:	· 5 \$ \$
NCR:	/es	/ No					WORK ORDER NON-C	O	VFORI	MANCE / UP	DATE			•
		,	,									QA Closed:	Date:	·
Nork Ord	or.						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
VOIR OIG	-1.		<u> </u>		<u></u>		Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.						Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•						Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR No.							Work Order Update Large Fab Composite						Supplier	
Root		_			Des		otion of work order update	nitial		tion	Sign &	M. Markey	061	
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data														
quip/Tooling	-													
perator			:								•			
laterial etup -														
ther	-	-			*			1						
rocess														
upplier							•			è				
raining									·	1				
napproved				ļ										
							F/	AUL	T CATE	GORY				
Landi	ng (ear					General		_			_		_
		Bending					Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	O/S		BOM/Route		Hardwa	re	:	Over/Under	tolerance	Temperature/Cure
		Cracks			,		Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped.	-			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs					Contamination		Mainte			Part Moved		
		Heat Trea					Countersink		Mislabe			Positioned V		-
	_	Inspection		Tube			Cut Too Short		Misread	t t		Power Loss/	Surge	Other
		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	Extrusio	n		Drawing		Out of	Calibration				
		Turning Se	equence		Finish Out of Sequence									
		Wave/Twi	ist in Tub	oe e			Folio	1	Outside	Dimensions				

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Picklist Print

• August-03-12 3:25:23 PM

Work Order ID: 88814

D350-567-115

Parent Item Name: Interior Floor Window

88814

D350-567-115

Start Date: 03/08/2012

Required Date: 17/08/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

IPP Rev:A New Issue 04-08-24 JLM

IPP Rev:B CHG#2 ECN 1055 07-11-21 DD verified by:EC

	IPP Rev:C 08-10-	07 as per revD	DD ve	rified by:									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Sta	tus
AN526C632R12		Purchased	No			110	Each	131.0000		9	~		
*AN526C	632R12								**	122	814	20	
SMO				Location	<u>!</u>	Loc	<u>Oty</u>	Loc Code					
3 1.1				ST344			100				_		
				ST346	122378		100		_		_	-	
				31340	121556		30 30						
				ST347			1						
					119225		1				_	1	
D2463		Manufactured	No			110	f	474.9074	4.41	4.41			
\$ D2469 * Seal									**				
53" mosm	SWS			Location	<u>!</u>	Loc	Oty	Loc Code				ri,	
54> 53" mosm	3142			ST404		474.9	00737		_				
٠, ٠					72232		15.38		_		_		
					79478 83542		3737 59.09		F	3542	_		
1X (d2463-0530 AS PER D	WG) CUT TO 53.00	,n							Ų.		_	1	
D3293-1		Manufactured	No			110	Each	12.0000		1 ~			
*D3293-11	k								**			<i></i>	
S31 HOD	so SM>			Location	1	Loc	<u>Oty</u>	Loc Code					
SH	≫			ST211			12				_		



Location	Loc Qty	Loc Code
ST211	12	
84073	6	
86851	6	

											DQA:	Date:	3	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPD	ATE				
									,		QA Closed:	Date:	•	
Work Orde	er·					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•	
Part No						Rework Skid-tube Machining Use-as-is Thermoforming Work Order Update Large Fab			Machining noforming	Crosstube Small Fab Finishing Composite	4	Water Jet Engin Prod. Eng. Coor. Rec/Store/Packaging Supplier		
Root Desc						ption of work order update		Initial Action			Sign &	I	Ī	
Cause		Date					1	Chief Eng Description			Date	Verification	QC Inspector	
Doc/Data	\sqcap	Date	эсер	City		or Non-comormance	C1	ilei Liig	Descri	ption	Date	Vernication	QC IIIspector	
Equip/Tooling											ļ			
Operator	Н										İ			
Material	Н													
Setup								٠						
Other	H													
Process	П													
Supplier	П													
Training	П													
Unapproved	П													
						F	AUL	T CATE	GORY		1			
Landi	ng Ge	ear				General								
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld	
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance		Part Moved			
	Heat Treat					Countersink	Mislabeled				Positioned \	Wrong		
	Inspection Strip in Tube					Cut Too Short		Misread	1		Power Loss	/Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

* August-03-12 3:25:23 PM

Work Order ID: 88814 Parent Item:

D350-567-115

Parent Item Name: Interior Floor Window

88814

D350-567-115

Start Date: 03/08/2012

Required Date: 17/08/2012

Start Qty: 1.00

Required Qty: 1.00

D3294-1

Bracket

D3295-04 Floor Window

SWO

D3296-041

Door Assembly

SW>

MS20470AD4-5

Rivet, Universal Head

Manufactured

Manufactured

Manufactured

Purchased

No

No

No

No

110

Each

8.0000

**

Location Loc Qty Loc Code ST212 64793 84071 7 110 Each

10.0000

**

Location Loc Qty Loc Code ST212 10 86516 10

110

Each 1.0000

89186

Location Loc Qty Loc Code ST218 84072

110 Each 2,582.000

717

/12/4/8 St

Location Loc Qty Loc Code 334 1500 122452 1500 ST319 1082 118405 365

120142

											DQA:	D	ate:	\$ # [*]
NCR:	res / N	0			WORK ORDER NON-O	O	NFORM	MANCE / UP	DATE		•		•	ſ
									:		QA Closed:	D	ate:	
Work Orde	or:				DISPOSITION				AGAINST I	DE	PARTMENT/	PROCESS		•
Part No. NCR No.					Scrap Machining Small I Use-as-is Thermoforming Finish				Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Quality Rec/Store/Packaging Other				
Root				Descri	ption of work order update	ı	nitial	Act	tion		Sign &			
Cause	Dat	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data														
Equip/Tooling													ļ	
Operator						ĺ								
Material			ļ										i	
Setup				,										
Other			1											•
Process											:			
Supplier			l					= = =						
Training		į												
Unapproved									•					
					F	AUL	T CATE	GORY			<u> </u>			
Landi	ng Gear				General		_				_			.
	Bendir	ng			Bend		Grain				Ovalized			Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	L	Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct	L	Weld
	Crushe	d/Crimped	l.		Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance			Part Moved			-
	Heat T	reat			Countersink		Mislabe	eled			Positioned V	Vrong		
	Inspec	tion Strip ir	n Tube		Cut Too Short	Misread					Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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3 August-03-12 3:25:24 PM

Work Order ID: 88814

Parent Item:

MS20470AD4-6

D350-567-115

Parent Item Name: Interior Floor Window

88814

D350-567-115

Start Date: 03/08/2012

Required Date: 17/08/2012

Start Qty: 1.00

Required Qty: 1.00

No

Purchased

110

Each

3,400.000

2,621.000

115 ~

**

Purchased

No

Location Loc Qty 336 1500 122452 1500 ST319 1900 117395 16 118927 165 119109 12 120142 81 121524 1626 110 Each

Loc Code 122452

15

**

Rivet, Universal Head

MS20470AD4-7

Location	Loc Qty	Loc Code
336	1300	
122452	1300	
ST139	1004	
121415	1004	
ST319	52	
120769	52	
ST320	265	
116081	117	
118614	148	

122462	
	

NCR	Yes	1	No
MKK.	YPS	- /	เงก

DQA: Date:

NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
													•
Work Ord	or.		,			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
WOIR OIG	CI.			 -		Rework	۱ ۱		Skid-tube	Crosstube]	Water Jet	Engineering
Part I	No.					Scrap Machining Small Fab				Pro	d. Eng. Coor.	Quality	
	•					Use-as-is Thermoforming Finishing				Rec/Stor	re/Packaging	Other	
NCR I	No.					Work Order Update			Large Fab	Composite]	Supplier	
Root					Descr	ription of work order update Initial Action				on	Sign &]
Cause		Date	Step	Qty		or Non-conformance	Ch	hief Eng Description			Date	Verification	QC Inspector
oc/Data					1								
quip/Tooling													
perator							ļ						
/laterial													
etup													
Other													
rocess									[į
upplier													
raining									1				
Inapproved			<u> </u>	<u> </u>					<u></u>		<u> </u>		1
							FAUI	LT CATE	GORY				
Landi	ng (1				General ¬₋.		1		 	٦		7_ ,_
	<u> </u>	Bending				Bend	<u> </u>	Grain		ļ	Ovalized	-	Pressure/Forced
	<u></u>	Centre No	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa		-	Over/Under	 	Temperature/Cure
	<u></u>	Cracks			<u> </u>	Broken/Damaged	\vdash	4 '	ion Incomplete		Part Incorre	 	Weld
	<u> </u>	Crushed/	Crimped		<u> </u>	Burrs	<u> </u>	4	tions Incomplete/U	Inclear	Part Lost/M		Wrong Stock Pulled
	_	Cuffs			<u> </u>	Contamination	<u> </u>	Mainte		<u> </u>	Part Moved		
	<u> </u>	Heat Trea			<u> </u>	Countersink	\vdash	Mislabe		<u> </u>	Positioned V	_	.
	L	Inspection	•	Tube	ļ	Cut Too Short	_	Misread	d		Power Loss/	'Surge	Other
	<u> </u>	Ripples in				Drill Holes	<u> </u>	Offset					
	<u></u>	Torque W			n	Drawing	\perp	_	Calibration				
Turning Sequence Finish							Out of S	Sequence					
	1	Wave/Tw	ist in Tul	he	1	Folio	- 1	Outside	Dimensions				

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August-03-12 3:25:24 PM

Work Order ID: 88814

Parent Item:

D350-567-115

Parent Item Name: Interior Floor Window

88814

D350-567-115

Start Date: 03/08/2012

Required Date: 17/08/2012

Start Qty: 1.00

**

Required Qty: 1.00

MS21042L06

NAS1149DN632J

Purchased

No

110

577.0000

Each

Purchased

No

Location Loc Qty Loc Code 315 300 122441 300 ST300 77 121556 77 ST317 200 122151 200 110

Each 332.0000

**

Location Loc Oty 298 200 122441 200 ST298 132 118428 132 Loc Code

										DQA:	Date:	, ·	•
NCR: Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE	·	· · · · · ·		•
										QA Closed:	Date:	-	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	r	
Part No.					Rework Skid-tube Crosstube Scrap Machining Small Fab				Pro	Water Jet d. Eng. Coor.	Engineering Quality	7	
NCR No.					Use-as-is Work Order Update	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other]		
Root				Descri	ption of work order update		Initial Action hief Eng Description			Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch				Date	Verification	QC Inspector	r
Doc/Data Equip/Tooling Operator Material Setup Other Process													

·		F	AUI	LT CATEGORY		
Landing Gear		General		_	 _	
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	_
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset	_	,
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish ·		Out of Sequence		
	Wave/Twist in Tube	Folio	Γ	Outside Dimensions		

Supplier Training Unapproved

REFERENCE ONLY

DART AEROSPACE LTD.



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PARTS LIST 5.0

Qty	Qty	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
-015	-017	-025	-021	-111	-11/	D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
X							
	Х					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		Х				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			Х		1	D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
		1			Х	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		i		1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1	i		1	D350-567-031	INTERIOR FLOOR WINDOW KIT
	1		i				(SLIDING DOOR COMPATABLE)

Qty	Qty	Qty	,Qty ₂	Qty		
-013	-023	-113	-115	-031	Part Number	Description
X			h		D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		Х			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				Х	D350-567-031	INTERIOR FLOOR WINDOW KIT
						(SLIDING DOOR COMPATABLE)
11					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12	-		2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9,OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ.	2 SQ.	2 SQ.			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
YD	YD	YD				
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
	_			- 1	D3210-1	BRACKET
				1	D3211-1	FLOOR WINDOW
				1	D3212-1	DOOR ASSEMBLY
			سر داے		-D3213-041	DOUBLER DOUBLE
			=======================================		D3294-1	-BRACKET
-			<u> </u>		D3295-041	-FLOOR WINDOW-
					D3296-041	DOOR ASSEMBLY
						NEOPRENE SEAL
			<u>عام</u>	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			4 -	8	AN960JD6	-WASHER
			295	8	MS21042L06	NUT (OR MS21042-06)
			C22	~~40 ~	MS20470AD4-5	RIVET
			C1:153/		MS20470AD4-6	RIVET
			615	~20	MS20470AD4-7	RIVET 1
		<u></u>	- 13	-20		''''

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Revision: D

Date: 08.07.08